

Work Order ID 140548

140548

Page 1

Thursday, January 07, 2016 1:27:41 PM

Item ID: D3885-3 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Standard Web

Start Date: 1/7/2016 Start Qty: 4.00 *4*

Required Date: 1/7/2016 Req'd Qty: 4.00 *4*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLJ Date: JAN 07 2016 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3885	B C 9-89 160307								
102		0.00							
102									
Skidtubes	Memo N/A	0.00							
Skidtubes	CUT BLANKS TO 120.00"								
105	QC5- Inspect part completeness to step on W/O	0.00							
105									
QC	Memo	0.00							
Quality Control									

DAS
13
9-89

JAN 15 2016

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : ☐			
Misidentified ☐		Past Due ☐					

Work Order ID 140548

140548

Page 2

Thursday, January 07, 2016 1:27:41 PM

Item ID: D3885-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Standard Web

Start Date: 1/7/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/7/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

108

0.00

108

Purchasing

Memo

0.00

Purchasing

Purchasing

Issue P/O: 31017

Supplier: WEJAY.

Machine as per Dwg D3885

Conformity sheet required

DAS
13
9-89

JAN 15 2016

4

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

DAS
6
9-89

FEB 2 - 2016

9

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

(4) 16-03-07 PS

P.T.O.

* 125

Skirtube: Rework AS Per ECN 16-526
TO REV. C. (H) 16-3-7

DP 16-3-7

DQA:

Date: 16.05.27



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: 16/05/16

Work Order update only ☐

Work Order: 140548 Part No. D3885-3 NCR No. 16-5662		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☒ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐			
Date: 16-02-23		Step #: 103		QTY Effective: 4		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition		DAS 9 9-89 16-02-23	
Web was fabricated as per drawing, but as of this date they are now under review. URF 16-526				Hold hold part in quarantine until newest rev is released. rework as per drawing Rev C.		Completed By 16-3-7 Lead hand / Supervisor Approval Verification PD 16-03-07 QC / QA Coordinator Approval PD 16-03-07	
Root Cause Environment ☐ No Re-verification ☐ Design ☒ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☒ Heat Treat ☐ Cut Too Short ☐ Mislabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐					
OTHER: ☐							

Work Order ID 140548

140548

Page 3

Thursday, January 07, 2016 1:27:41 PM

Item ID: D3885-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Standard Web

Start Date: 1/7/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/7/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

DD 16-3-9

140

QC - Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

Sh 16-3-9
PTO

150

Identify as per dwg & Stock Location: _____

0.00

150

Packaging

Memo

0.00

Packaging

LOCATION: LG002

DD 16-3-9

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
Shelf Read QC 7					
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
		OTHER : _____			

Work Order ID 140548

140548

Page 4

Thursday, January 07, 2016 1:27:41 PM

Item ID: D3885-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Standard Web

Start Date: 1/7/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/7/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

MCJ

MAR 10 2016

MCJ

MAR 10 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : ☐			
Misidentified ☐		Past Due ☐					

Picklist Print

Thursday, January 07, 2016 1:27:44 PM

Page 1

Work Order ID: 140548

140548

Parent Item: D3885-3

D3885-3

Parent Item Name: Standard Web

Start Date: 1/7/2016

Required Date: 1/7/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3885-3P		Purchased	No				Each	0.0000		4	DAS 6 8-89		
D3885-3P									**				MAR 11 2016
Standard Web													
D3882-1-130		Manufactured	No			110	Each	71.0000	1	4	DAS 13 9-89	JAN 15 2016	
D3882-1-130									**				
Extrusion "I" Beam													

Location

Loc Qty

Loc Code

HALL

65

137403

65

LG002

6

119702

6

4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

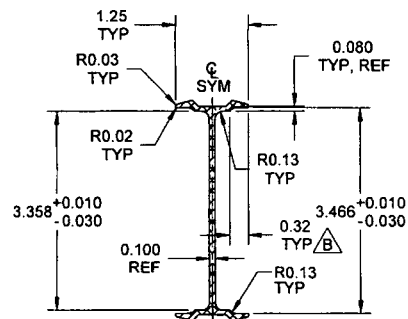
SHOWING
 UNCOMPLETED
 SUBJECT TO
 WORK
 NO. 140548 MJS
 1601-07

D3885-1 STANDARD WEB

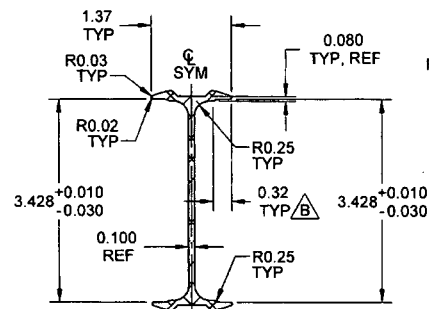
D3885-3 FLOAT WEB

RELEASED
09/07/15

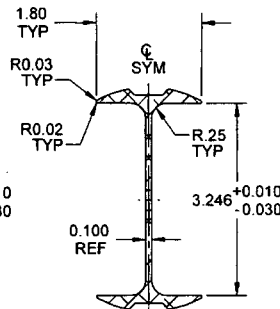
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A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3885	SHEET 1 OF 5
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEB	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



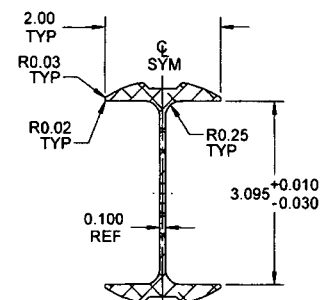
**SECTION A-A
& SECTION J-J**
SCALE 5X
D6-2
D4-2



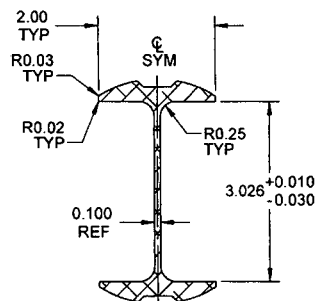
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SCALE 5X
D6-2



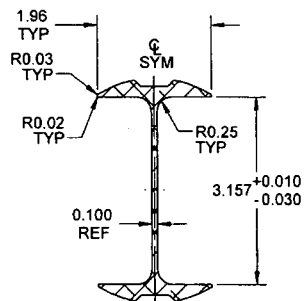
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D6-2



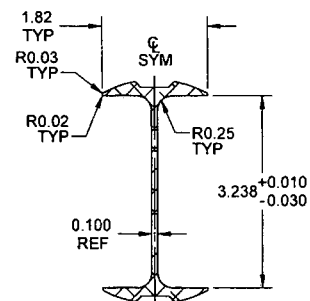
SECTION D-D
SCALE 5X
D5-2



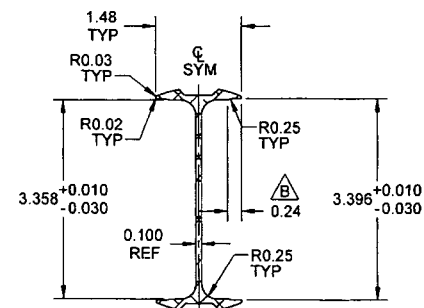
**SECTION E-E
& SECTION F-F**
SCALE 5X
D5-2



SECTION G-G
SCALE 5X
D4-2



SECTION H-H
SCALE 5X
D4-2

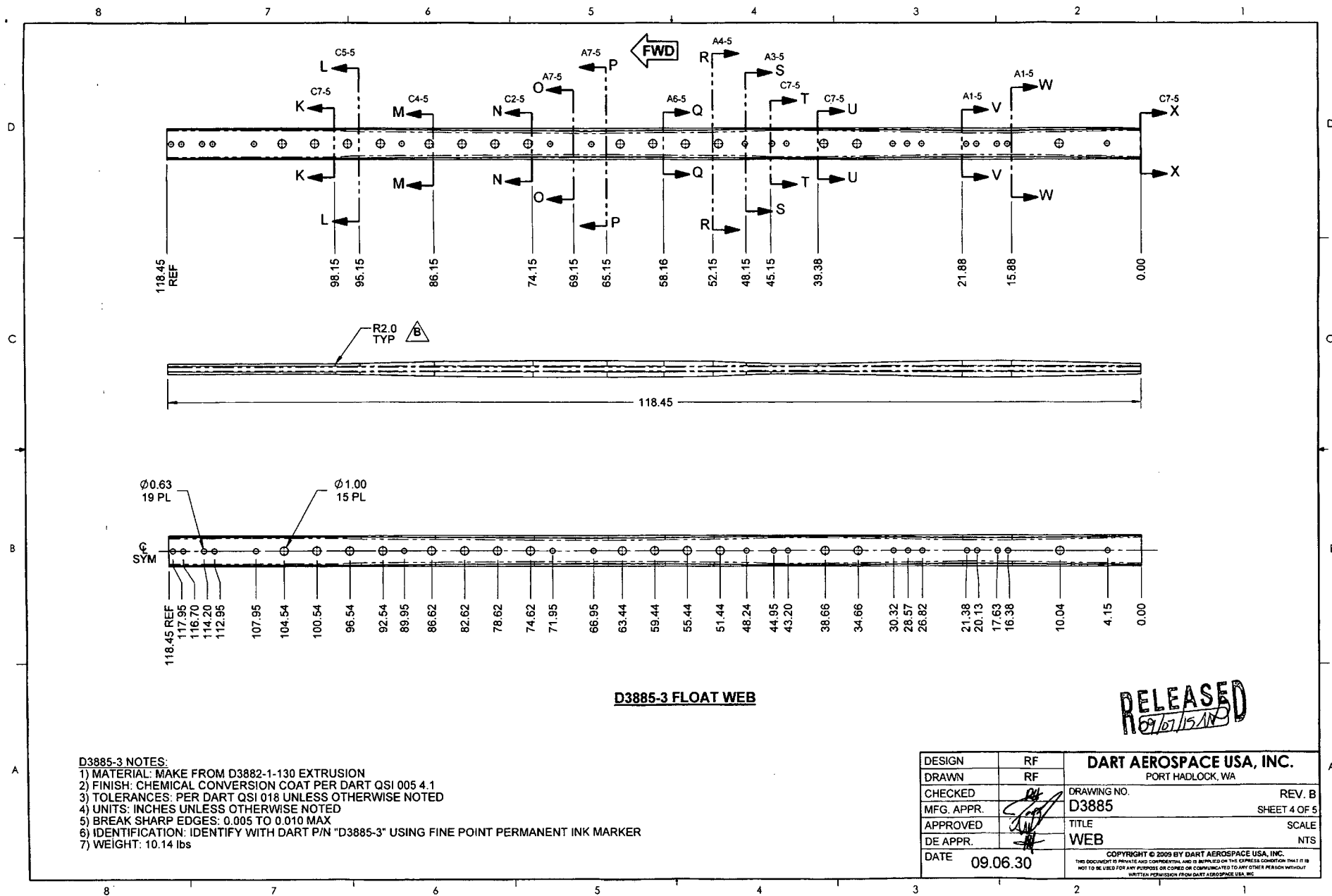


SECTION I-I
SCALE 5X
D4-2

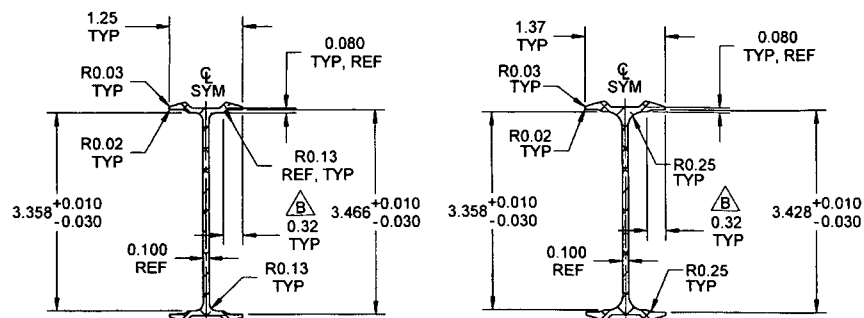
D3885-1 STANDARD WEB SECTION VIEWS

RELEASED
2/7/15

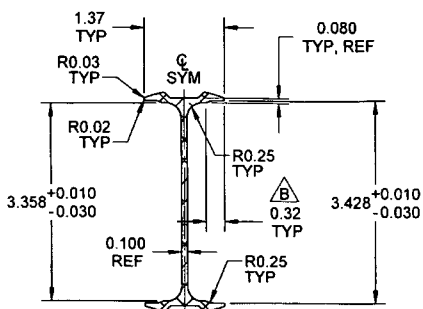
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3885	REV. B
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE WEB	SCALE NTS
DE APPR.		COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	
DATE	09.06.30		



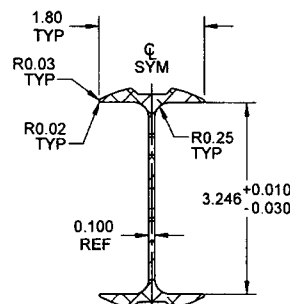
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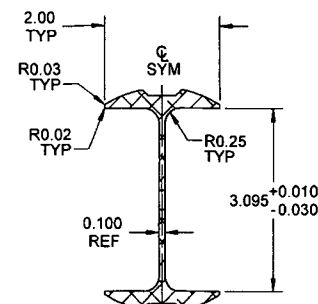
**SECTION K-K
& SECTION T-T
& SECTION U-U
& SECTION X-X**
SCALE 5X
D7-4
D4-4
D3-4
D1-4



SECTION L-L D6-4
SCALE 5X

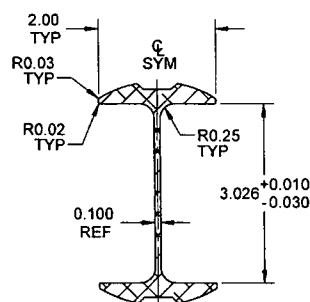


SECTION M-M D6-4
SCALE 5X

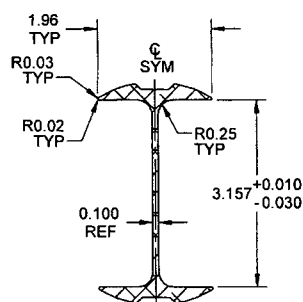


SECTION N-N D5-4
SCALE 5X

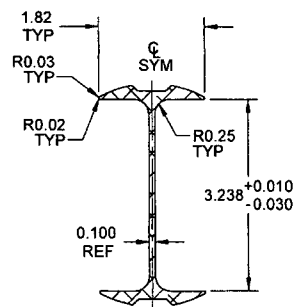
RELEASED
3/17/54



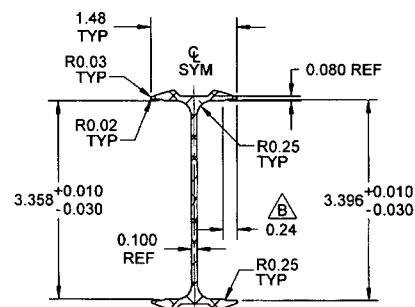
**SECTION O-O
& SECTION P-P** D5-4
SCALE 5X



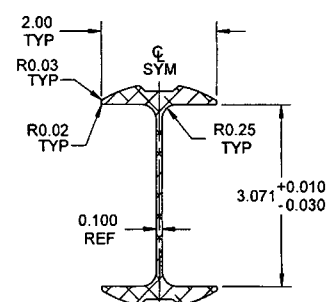
SECTION Q-Q D4-4
SCALE 5X



SECTION R-R D4-4
SCALE 5X



SECTION S-S D4-4
SCALE 5X



**SECTION V-V
& SECTION W-W** D3-4
D2-4
SCALE 5X

D3885-3 FLOAT WEB SECTION VIEWS

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31017**

Purchase Order Date 1/15/2016

PO Print Date 1/15/2016

Page Number 1 of 2

Order From :

VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
JAN 15 2016

Contact Name

Vendor Phone 613-384-1662

Ship To Contact

Ship To Phone

Ship Via: Journey Freight ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4821-1P	Windshield Deflector	2/19/2016 Yes 2/19/2016		6.00 Each	\$1,150.00	\$6,900.00

MACHINE AS PER DWG D4821 REV. B
B140556

Line Total: \$6,900.00

2	D3885-3P	Standard Web	2/19/2016 Yes 2/19/2016		4.00 Each	\$550.00	\$2,200.00
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MACHINE AS PER DWG D3885 REV. B
B140548

16/2/22

Line Total: \$2,200.00

PO Instructions: QUOTATION NO. WJ-8795

Note:

1/15/2016



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER:	DATE: Feb. 2, 2016		
	P.O.# PO31017		
	WEJAY JOB# 37770		
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D3885-3P 'Float Web'	4	Machined complete per drawing req'ts.	D3885 / rev. B
Note: 1) Material supplied by Dart Aerospace. 2) 1st Article Inspection Report attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

Clifford Smith
Authorized Q.A. Signatory

First Article Inspection Report

(Report all dimensions and features required by drawing)

Customer : DART AEROSPACE

Page 1 of 4

Customer P.O. No.: P031017

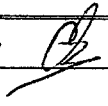
Wejay Job No.: 37770

Part Description: FLOAT WEB

Part Serial No.: —

Manufacturing Production Order Operation No.: 30

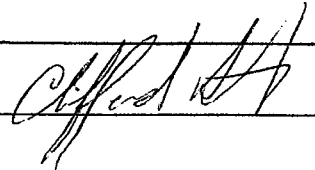
Drawing Number (Including Revision): D3885 REV.B

Drawing Balloon Item (When attaching drawing to itemize features)	Dimension Required	Actual Dimension recorded
SEE ATTACHED IWSR	REPORT 	

Equipment Used: _____

☒ Accepted ☐ Not Accepted NCR (If applicable) _____

Reviewed by:

Production: 

Date: _____

Quality Control: _____

Date: JAN 28 / 16



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 37770

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO31017

PART No. D3885-3P

DESCRIPTION: Float Web

DWG No. D3885 - sheets 4-5

REV. B

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR:

QUANTITY
REC'D: 1

ACCEPT: 1

REJECT: —

N.C.R.# --

DATE: JAN 28/16

INSTRUCTIONS, COMMENTS:

ITEM REF. No.	CHARACTERISTIC (DIMS IN mm)	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	Hole, Diameter .63"	19 places	+ .008/- .001		.634 TYP.	1	Acc.
2	Hole, Diameter 1.00"	15 places	+ .010/- .001		1.004 TYP.	1	"
3	4.15"		+/- .03		4.151	1	"
4	10.04"		+/- .03		O.K.	1	"
5	16.38"		+/- .03		O.K.	1	"
6	17.63"		+/- .03		O.K.	1	"
7	20.13"		+/- .03		O.K.	1	"
8	21.38"		+/- .03		O.K.	1	"
9	26.82"		+/- .03		O.K.	1	"
10	28.57"		+/- .03		O.K.	1	"
11	30.32"		+/- .03		O.K.	1	"
12	34.66"		+/- .03		O.K.	1	"
13	38.66"		+/- .03		O.K.	1	"
14	43.20"		+/- .03		O.K.	1	"
15	44.95"		+/- .03		O.K.	1	"
16	48.24"		+/- .03		O.K.	1	"
17	51.44"		+/- .03		O.K.	1	"
18	55.44"		+/- .03		O.K.	1	"
19	59.44"		+/- .03		O.K.	1	"
20	63.44"		+/- .03		O.K.	1	"
21	66.95"		+/- .03		O.K.	1	"
22	71.95"		+/- .03		O.K.	1	"
23	74.62"		+/- .03		O.K.	1	"
24	78.62"		+/- .03		O.K.	1	"
25	82.62"		+/- .03		O.K.	1	"
26	86.62"		+/- .03		O.K.	1	"
27	89.95"		+/- .03		O.K.	1	"
28	92.54"		+/- .03		O.K.	1	"
29	96.54"		+/- .03		O.K.	1	"
30	100.54"		+/- .03		O.K.	1	"
31	104.54"		+/- .03		O.K.	1	"
32	107.95"		+/- .03		O.K.	1	"
33	112.95"		+/- .03		O.K.	1	"
34	114.20"		+/- .03		O.K.	1	"
35	116.70"		+/- .03		O.K.	1	"

INSPECTION / TEST REPORT

JOB No. 37770

PAGE: 2 of 3

CUSTOMER: Dart Aerospace

CUST. P.O. PO 31017

PART No. D3885-3

DESCRIPTION: Float Web

DWG No. D3885 - sheets 4-5

REV. B

E.C.O. --

REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
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36	117.95"		+/- .03		O.K.	1	Acc.
37	1.25" TYP	Section K-K,T-T,U-U,X-X			1.260-1.285	1	NIA ATENDJ
38	R.03" TYP				O.K.	1	Acc.
39	R.02" TYP				O.K.	1	"
40	3.358"		+0.010/-.030		3.349/3.365	1	"
41	R.13" TYP				R.125 TYP.	1	"
42	.32" TYP				O.K.	1	"
43	3.466"		+0.010/-.030		3.456-3.475	1	"
44	R.13" TYP				R.125 TYP.	1	"
45	.080 TYP, REF				O.K.	1	"
46	1.37" TYP	Section L-L			1.381	1	"
47	R.03" TYP				O.K.	1	"
48	R.02" TYP				O.K.	1	"
49	3.358"		+0.010/-.030		3.355/3.362	1	"
50	R.25" TYP				R.25 TYP.	1	"
51	.32" TYP				O.K.	1	"
52	R.25" TYP				R.25 TYP.	1	"
53	3.428"		+0.010/-.030		3.425-3.435	1	"
54	1.80" TYP	Section M-M			1.815	1	"
55	R.03" TYP				O.K.	1	"
56	R.02" TYP				O.K.	1	"
57	3.246"		+0.010/-.030		3.235/3.252	1	"
58	R.25" TYP				R.25 TYP.	1	"
59	2.00" TYP	Section N-N			1.985 (STOCK)	1	"
60	R.03" TYP				O.K.	1	"
61	R.02" TYP				O.K.	1	"
62	3.095"		+0.010/-.030		3.089-3.101	1	"
63	R.25" TYP				R.25 TYP.	1	"
64	2.00" TYP	Section O-O,P-P			1.985 (STOCK)	1	"
65	R.03" TYP				O.K.	1	"
66	R.02" TYP				O.K.	1	"
67	3.026"		+0.010/-.030		3.035-3.025	1	"
68	R.25" TYP				R.25 TYP.	1	"
69	1.96"	Section Q-Q			1.965-1.971	1	"
70	R.03" TYP				O.K.	1	"
71	R.02" TYP				O.K.	1	"
72	3.157		+0.010/-.030		3.145-3.160	1	"
73	R.25" TYP				R.25 TYP.	1	"
74	1.82"	Section R-R			1.822/1.830	1	"

PAGE: 3 of 3

CUST. P.O PO31017

PART No.D3885-3

DESCRIPTION: Float Web

DWG No. D3885 - sheets 4-5

REV. B

E.C.O. --

REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
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[illegible]



Packing Slip 37749

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
 TEL: 613-384-1662 FAX: 613-384-2997
 www.wejay.com

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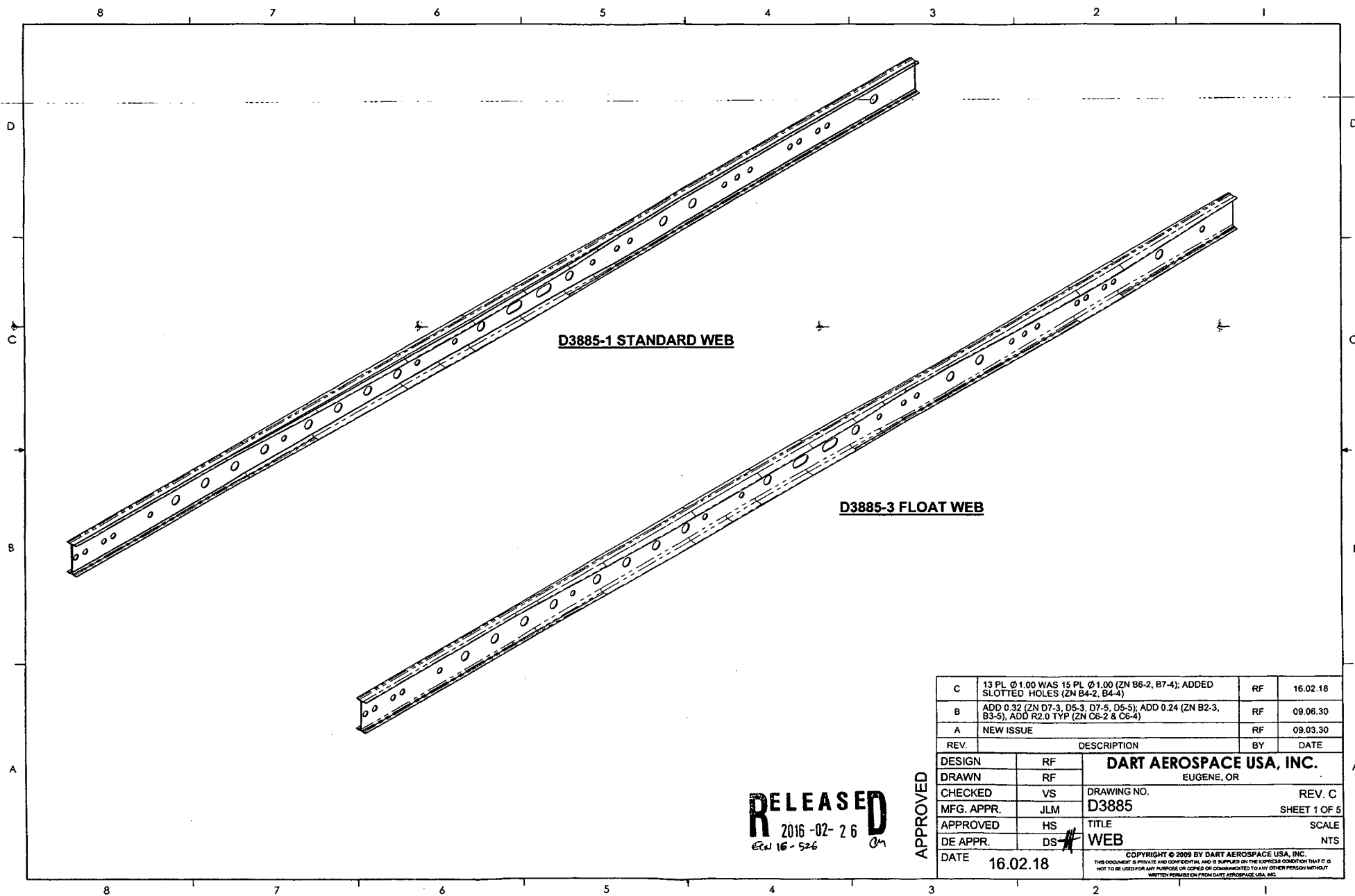
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INVOICE DATE		YOUR ORDER NO.		DATE ORDERED		SHIPPED VIA		
CUSTOMER CODE				PROV. LIC. NO.		TERMS		
				Extra ☐ Exempt ☐				
QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION				UNIT PRICE	AMOUNT
8	0	8	[Faint description text]					
8	0	9	[Faint description text]					
4	0	3	[Faint description text]					
6	0	6	[Faint description text]					
RELEASE NOTE I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order. Inspection Supervisor <u>[Signature]</u> WMP 03 G.S.T. P.S.T. FEB 11/16								
ORDER: COMPLETE ☐ PARTIAL ☐							TOTAL	

RECEIVED BY _____
 1.5% PER MONTH (18% PER ANNUM)
 CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
 PRIOR AUTHORIZATION



D3885-1 STANDARD WEB

D3885-3 FLOAT WEB

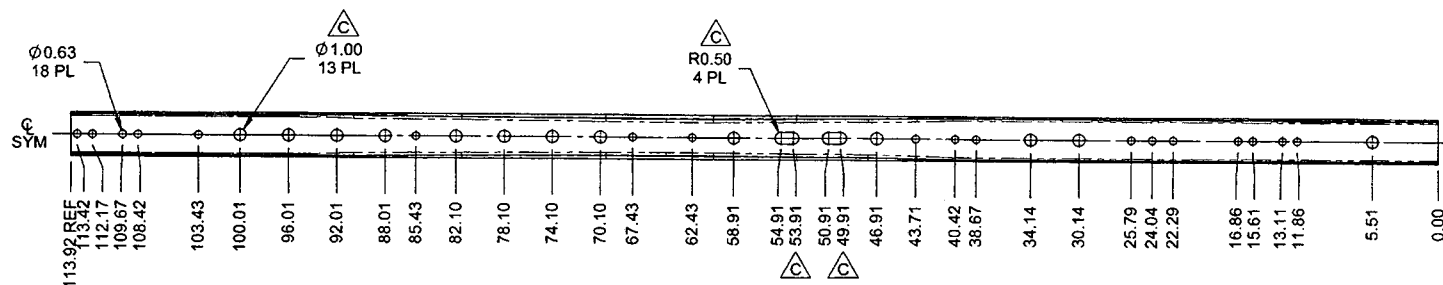
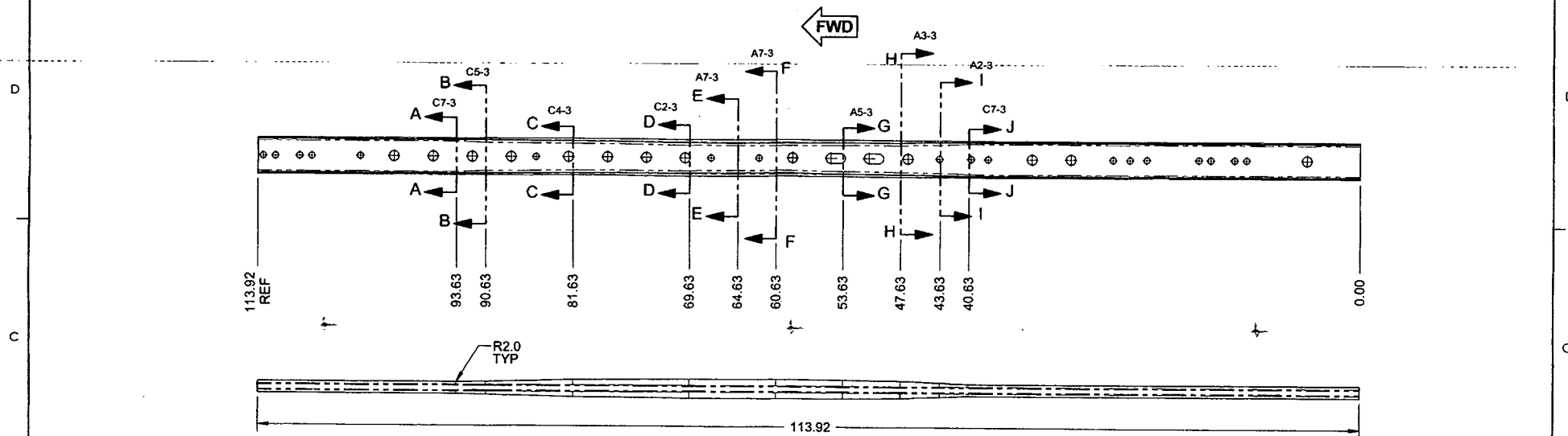
C	13 PL Ø 1.00 WAS 15 PL Ø 1.00 (ZN B6-2, B7-4); ADDED SLOTTED HOLES (ZN B4-2, B4-4)	RF	16.02.18
B	ADD 0.32 (ZN D7-3, D5-3, D7-5, D5-5); ADD 0.24 (ZN B2-3, B3-5), ADD R2.0 TYP (ZN C6-2 & C6-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	RF		
CHECKED	VS		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS	WEB	
DATE	16.02.18	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2016-02-26
ECL 16-526

APPROVED

REV. C
SHEET 1 OF 5
SCALE
NTS

8 7 6 5 4 3 2 1



D3885-1 STANDARD WEB

D3885-1 NOTES:

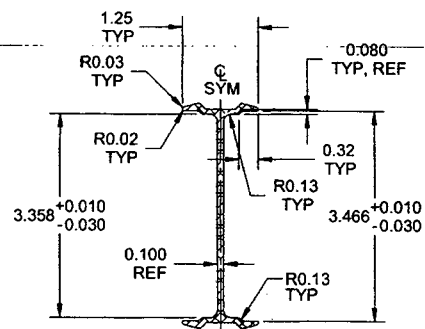
- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.49 lbs

RELEASED
2016-02-26

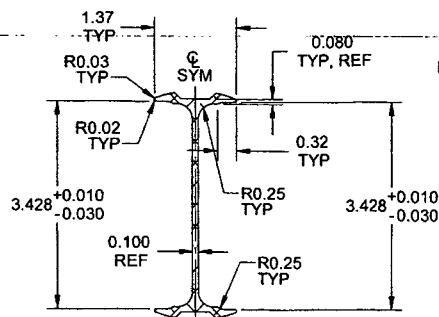
APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
DATE	16.02.18	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
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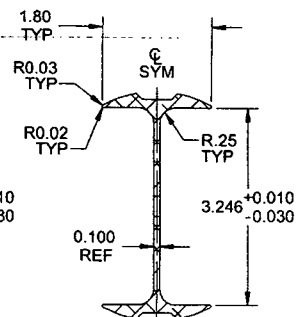
8 7 6 5 4 3 2 1



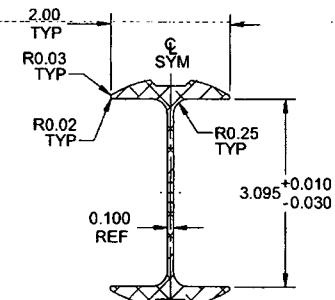
**SECTION A-A
& SECTION J-J** D6-2
D4-2
SCALE 5X



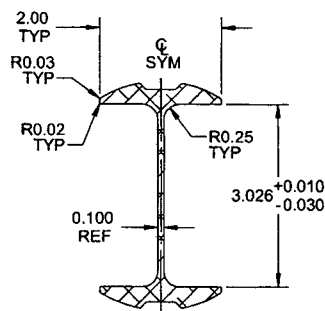
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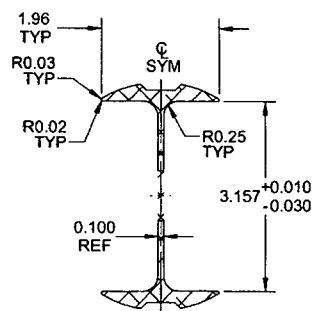
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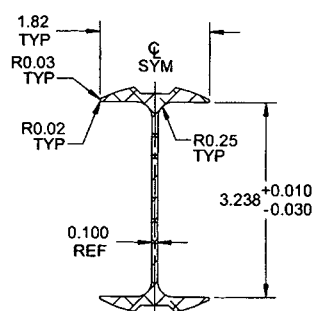
SECTION D-D D5-2
SCALE 5X



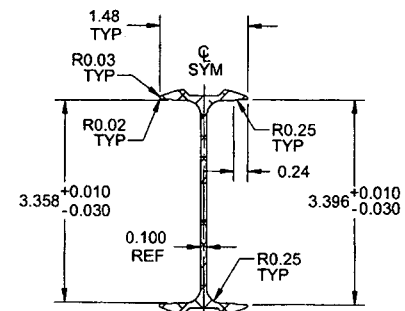
**SECTION E-E
& SECTION F-F** D5-2
SCALE 5X



SECTION G-G D4-2
SCALE 5X



SECTION H-H D4-2
SCALE 5X



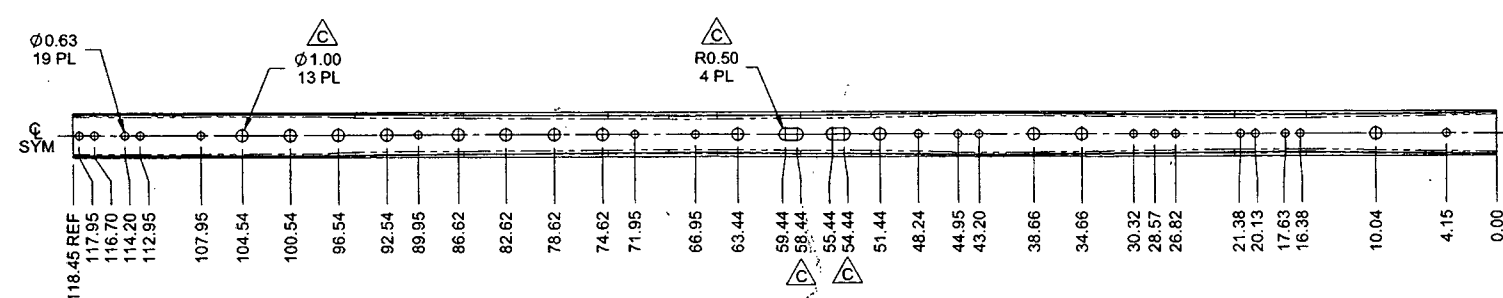
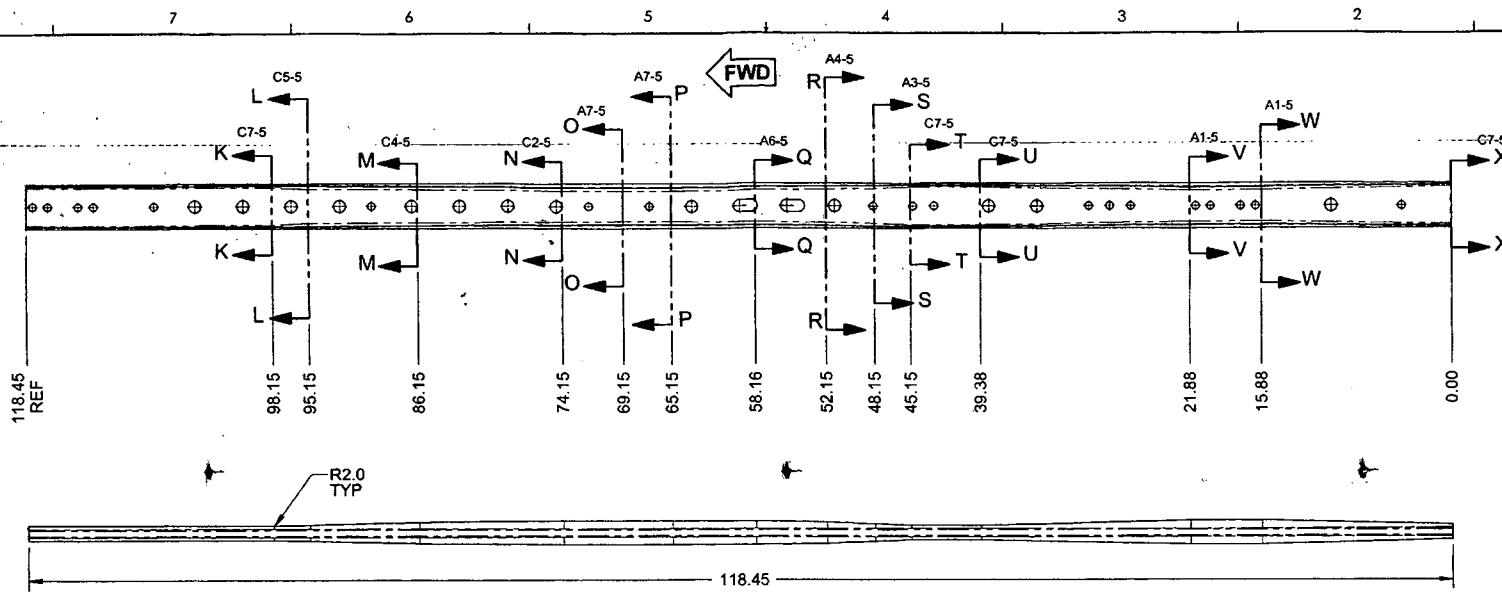
SECTION I-I D4-2
SCALE 5X

D3885-1 STANDARD WEB SECTION VIEWS

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2016-02-26

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEB	NTS
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D3885-3 FLOAT WEB

D3885-3 NOTES:

- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 004 6.1
- 7) WEIGHT: 10.14 lbs

RELEASED
2016-02-26

APPROVED

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	EUGENE, OR	
CHECKED	VS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3885	SHEET 4 OF 5
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